










Date: Wednesday, 20/05/2009 8:57:16 AM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WHEEL ASSEMBLY
Job Number	: 48015		
Estimate Number	: 12099		
P.O. Number	:	Part Number	: D3233041
This Issue	: 20/05/2009 S.O. No. :	Drawing Number	: D3233 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : LARGE FAB ASSY	Drawing Revision	: B
Previous Run	: 47494	Material	:
Written By	:	Due Date	: 27/05/2009 Qty: 2 Um: Each
Checked & Approved By	: <u>MF 09-05-20</u>		
Comment	: Est. C 05.07.18 D3233-5 was D3332-5; Qty changed by half K J/JLM		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
✓ 1.0	D32335	Hub Sleeve	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)			
Hub Sleeve			
Pick:			
Qty	Part Number	Description	Batch
1	D3233-5	Hub Sleeve	45171
SAD 09-06-01 (2)			
✓ 2.0	D32337	Shaft Sleeve	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)			
Shaft Sleeve			
Pick:			
Qty	Part Number	Description	Batch
1	D3233-7	Shaft Sleeve	B46045
SAD 09-06-01 (2)			
✓ 3.0	D32339	Tire & Rim Assembly	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)			
Tire & Rim Assembly			
Pick:			
Qty	Part Number	Description	Batch
1	D3233-9	Tire & Rim Assembly	B47607
SAD 09-06-01 (2)			
✓ 4.0	NKI 3020	BEARING	
			
Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)			
Bearing			
Pick:			
Qty	Part Number	Description	Batch
2	NKI 30/20	Bearing & Inner Sleeve	M41871
SAD 09-06-01 (2)			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 20/05/2009 8:57:16 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WHEEL ASSEMBLY

Job Number: 48015

Part Number: D3233041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SHIM STOCK

.004" Brass Shim Stock



Comment: Qty.: 4.0000 f(s)/Unit Total : 8.0000 f(s)
.004" Brass Shim Stock

Pick:

Qty Part Number Description

4 Shim Stock 0.004" thick Brass Shim Stock

Batch

M107282

SAD 09-06-01 (2)

6.0

35X45X7

Bearing Seal



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
Bearing Seal

Pick:

Qty Part Number Description Batch

2 35x45x7 Axel Seal

M111655

or CR 35x45x7 HMS4 R

SAD 09-06-01 (2)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Press out bearings that are supplied with D3233-9 wheel and discard them.

Cut shims and assemble as per Dwg D3233

Spray inside hub and bearing with LPS-3 & block hole with a clean dry rag for storage.

SAD 09-06-01 (2)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAD 09-06-01 (2)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

SAD 09-06-01 (2)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/02

Job Completion



MF 09-06-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

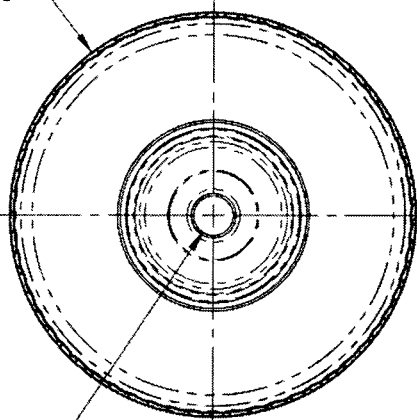
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

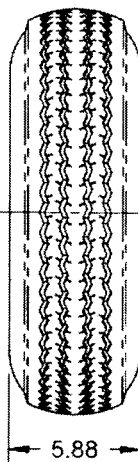


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3233	REV. B SHEET 1 OF 3
DATE 05.03.08	TITLE WHEEL ASSEMBLY		SCALE 1:1
A	05.02.18	NEW ISSUE	
B	05.03.08	ADDED BEARING SEALS	

Ø18.00



HUB
Ø1.78

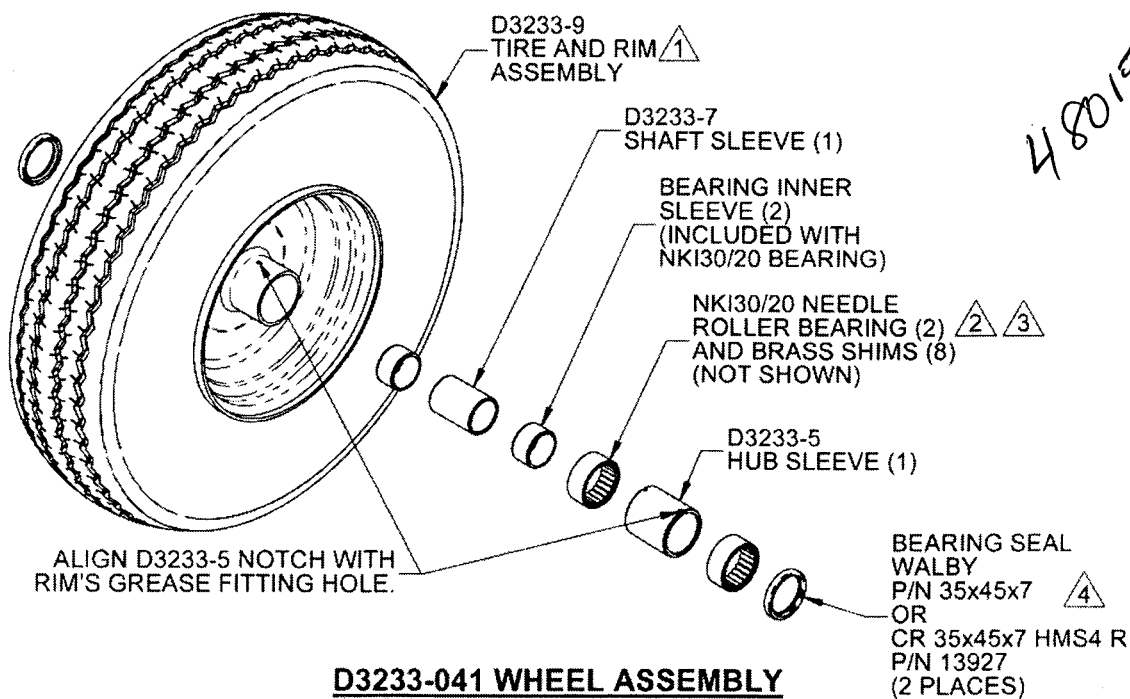


5.88

WHEEL SPECIFICATIONS

SIZE	MAXIMUM LOAD	MAXIMUM INFLATION LOAD
TIRE: 19.0 x 5.8 RIM: 5.70 x 8.0	910 LBS (RANGE C)	90 PSI*

* MANUFACTURER'S RECOMMENDATIONS ARE 75 PSI FOR HIGH SPEED USE.



D3233-041 WHEEL ASSEMBLY

NOTES:

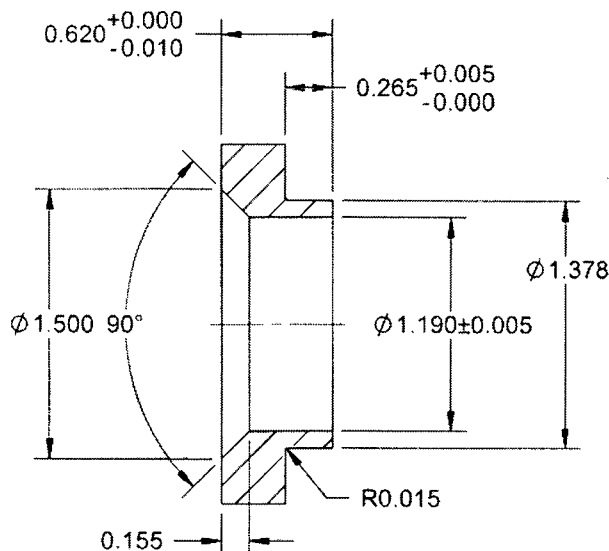
- 1) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 8353T74
- 2) POSSIBLE SUPPLIER: GENERAL BEARING
- 3) PRESS FIT NEEDLE ROLLER BEARINGS INTO RIM HUB WITH
(4) 0.5 X 0.75 X 0.004 BRASS SHIMS PER BEARING, (1) AT EACH QUADRANT.
- 4) POSSIBLE SUPPLIER: GENERAL BEARING
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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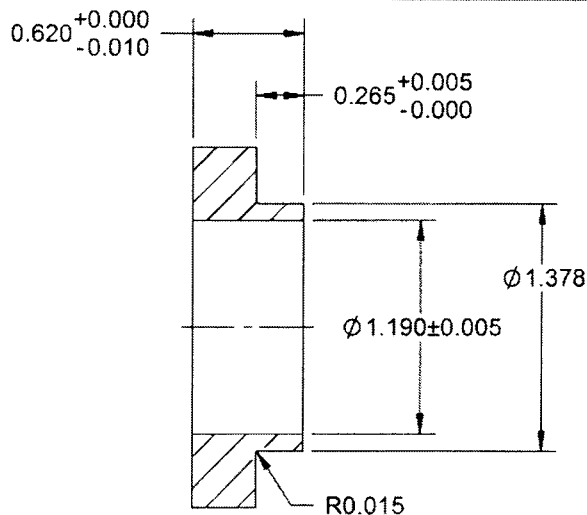
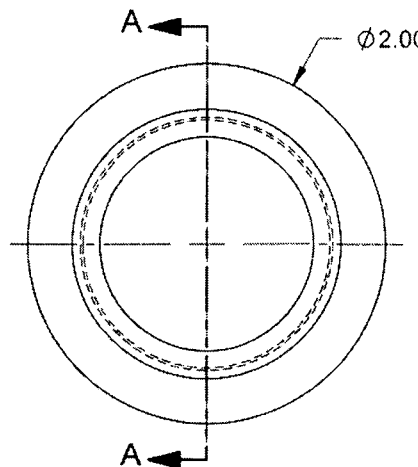


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3233	REV. B SHEET 2 OF 3
DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1



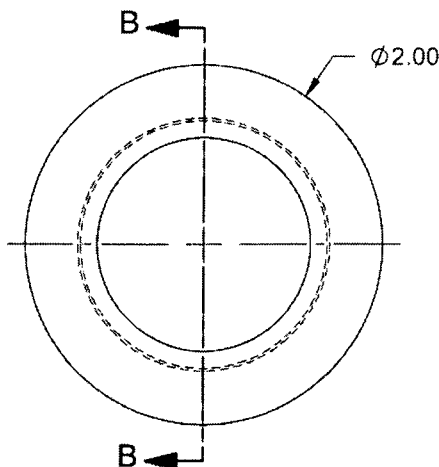
SECTION A-A

D3233-1 INSIDE WASHER



SECTION B-B

D3233-3 OUTSIDE WASHER



NOTES:

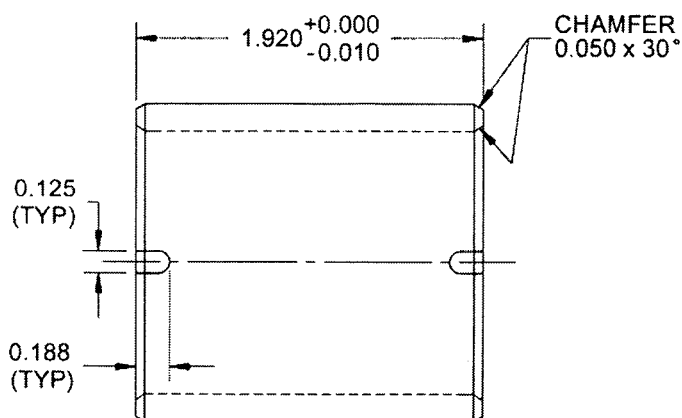
- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS (REF. DART SPEC. M1020TR)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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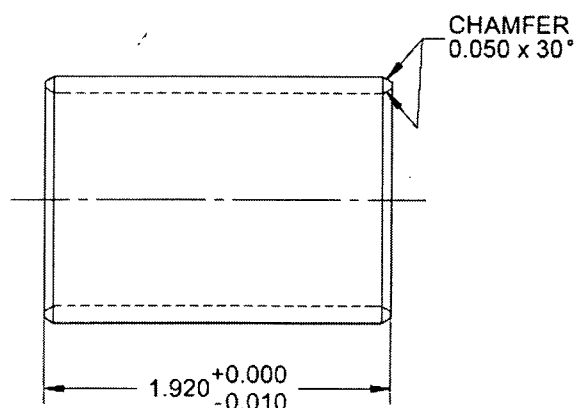
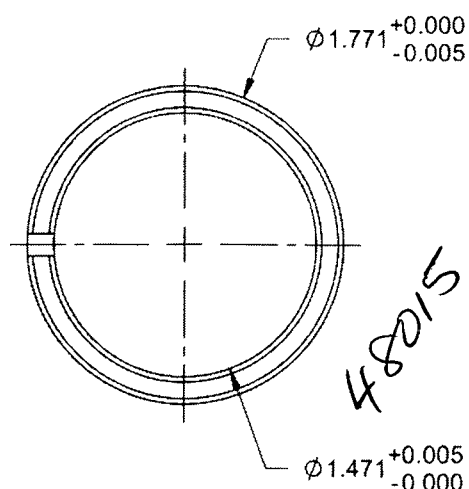
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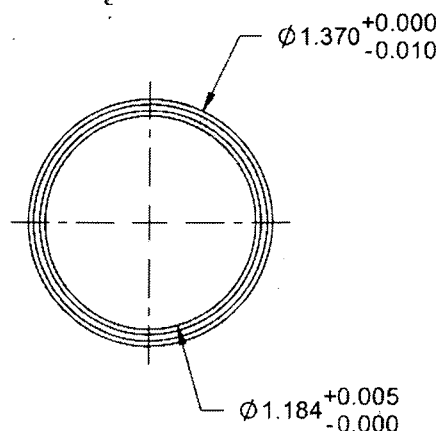
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3233	REV. B SHEET 3 OF 3
DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1



D3233-5 HUB SLEEVE



D3233-7 SHAFT SLEEVE



NOTES:

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00
MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS
(REF. DART SPEC. M1020TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.030

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